



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3290-041
Job Sheet 187735



Part No: D3290-041

Job Qty: 4 pcs

Part Name: Replacement Exterior Window For -111



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/13/18

Job Tracking No:

Due Date: 12/17/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP B 05.05.25 Added Step 11 KJ/JLM IPP C IPP Rev:D Now on Waterjet 06-06-16 JLM IPP rev E rev C dwg 07.09.28 EC verified by: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Small Fab - 1	4 pcs	12/17/18		0.00	1.72	Small Fab - 1	
							Small Fab - 2	
							Small Fab - 3	SAW F-02+05
							Small Fab - 4	
							Small Fab - 5	
							Small Fab - 6	DEC 21 2018
							Small Fab - 7	
170	QC 5	4 pcs	12/17/18		0.00	0.00	QC 5 - 10	
							QC 5 - 12	
							QC 5 - 16	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 38	
							QC 5 - 42	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	FEB 08 2019
							QC 5 - 9	DAS 68
							QC 5 - 50	9-89
							QC 5 - 30	
180	Packaging 3-1 - Stock - B4B	4 pcs	12/17/18		0.00	0.00	Packaging 3 - 1 - B4B	
							Packaging 3 - 2 - B4B	
							Packaging 3 - 3 - B4B	
							Packaging 3 - 4 - B4B	
							Packaging 3 - 5 - B4B	
							Packaging 3 - 6 - B4B	

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update _____

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	En _____ Proc _____ Rec/Stor _____																												
Date : _____		Sequence # : _____		QTY Affected : _____																												
Description Work Order Deviation			Disposition																													
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table style="width:100%;"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>			☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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		Other/Details:																														

Part: D3290 - 041
 Job No: 18735
 Serial No/Batch: S141212
 Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: Various STC's



AEROSPACE
-PART

URT Aerospace Ltd.
 1270 Ardmore Street
 Hemet, ON K6A 1K7
 CANADA
 TEL: 519 632-5200
 Email: sales@ardmore.com
 www.ardmore.com

Lead hand / Supervisor

QC / QA Coordinator

Packaging 3 - 7 - B4B
 Packaging 3 - 8 - B4B
 Packaging 3 - 9 - B4B
 Packaging 3 - 10 - B4B
 Packaging 3 - 11 - B4B
 Packaging 3 - 12 - B4B
 Packaging 3 - 13 - B4B
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 Packaging 3 - 34 - B4B
 Packaging 3 - 35 - B4B

5433 SA

FEB 11 2019

DAS
21

9-58

FEB 11 2019

190 QC 21 - SA 4 pcs 12/17/18 0.00 0.00 QC 21 - SA - 16

Part Op 100 - (Small Fab) ***Windows need to be protected at all time*** **DEBURR EDGE LIGHTLY*** Assemble as per Dwg
 Descriptions: D3290 VERIFY BY: _____ DATE: _____ Clean D3290-041, wrap in foam wrap and place in plastic
 wrap ***Inspection complete D2126 length of material needs to be check for any deformations, material build ups or issue
 that will lead to any rejections***
 170 - (QC5- Inspect part completeness to step on W/O)
 180 - (Identify as per dwg & Stock Location: _____)
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2126	Locking Seal (Sold Per Foot)	26 ft (6.5 ea)	100-Small Fab - 1	3107093
D3290-1	Frame	4 Ea (1 ea)	100-Small Fab - 1	3132126 x4 5143771 x2
D3290-3	Window	4 Ea (1 ea)	100-Small Fab - 1	5106466 x4 5142079 x1 5132041 x2

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	D2126	26	537	0
	D3290-1	4	8	0
	D3290-3	4	16	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
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